Dart Aerospace Ltd.

Date: Monday, 1/7/2008 3:38:33 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET
Job Number	: 36631		
Estimate Number	: 10283		
P.O. Number	:	Part Number	: D31991 X9
This Issue	: 1/7/2008 S.O. No. :	Drawing Number	: D3199 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 34515	Material	:
Written By	:	Due Date	: 1/25/2008 Qty: ~~80~~ 200 Um: Each
Checked & Approved By	: 08.01.08		
Comment	: Est Rev:C Removed Scribing 05-11-05 JLM		
	Est Rev:D As per Rev B . 06-11-24 JLM		

Additional Product

Job Number:

Seq. #	Machine Or Operation:	Description :
1.0	M304S20GA	304/316 .040 Sheet 101027 x 55 = 5.72 106702 x 75 = 7.8 23.608 105841 x 31 = 3.224 106292 x 36 = 3.744 106702 x 75 7.8 duplicate?
	Comment: Qty.: 0.1040 sf(s)/Unit Total : 8.3160 sf(s) 304/316 0.040" SHEET Batch: 106748 HB 8-1-9	
2.0	WATER JET 30 = 3.12	FLOW WATER JET
	Comment: FLOW WATER JET Cut as per Dwg D3199 Dwg Rev: B HB 8-1-9 Prog Rev: B Deburr if required HB 8-1-9	227
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	HB 8-1-9 Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK
	QSP 019 Comment: SECOND CHECK	08/01/10 4727 carts
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
	Comment: SMALL & MEDIUM FAB RESOURCE 1 Form as per dwg D3199	08/01/15 227

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Date: Monday, 1/7/2008 3:38:33 PM
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Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** BRACKET

Job Number: 36631 **Part Number:** D31991

Job Number:

Seq. #:	Machine Or Operation:	Description :
6.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	QSP012 08.11.15 x227
7.0	POWDER COATING	POWDER COATING
	Comment: POWDER COATING Powder Coat Gey Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3	M106442 POWDER COATING M-L 08/01/18 227x
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION	SP 8/1/18 227x
9.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: SS	8/1/18 SP 227x
10.0	QC21	FINAL INSPECTION/W/O RELEASE
	Comment: FINAL INSPECTION/W/O RELEASE	08.01.21

Job Completion

M 08.2.21

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	36631
Description: Bracket	Part Number:	D3199-1
Inspection Dwg: D3199 **Rev:** B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.210	+0.005/-0.001	.213	X			
0.575	+/-0.010	.577	X			
1.090	+/-0.010	1.090	X			
2.015	+/-0.010	2.015	X			
2.971	+/-0.010	2.970	X			
1.830	+/-0.010	1.822	X			
4.830	+/-0.010	4.822	X			
4.030	+/-0.010	4.030	X			

Measured by:	MA HB
Date:	8-1-9

Audited by:	
Date:	08/04/10

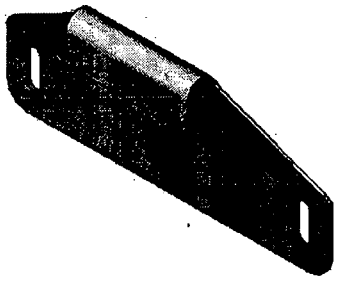
Prototype Approval:	N/A
Date:	N/A

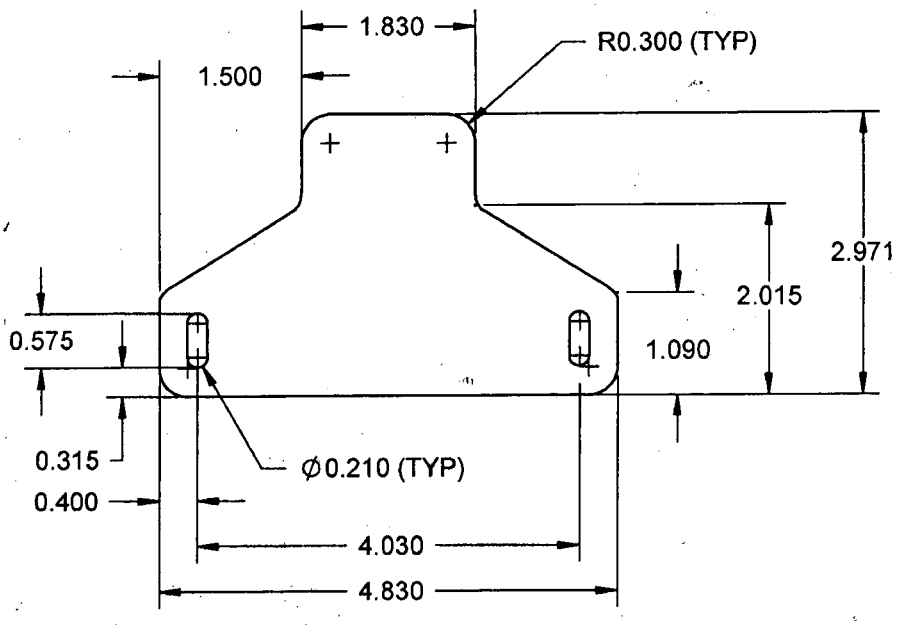
Rev	Date	Change	Revised by	Approved
A	06.10.20	New Issue	KJ/JLM	
B	06.11.24	Dwg Revision revised	KJ/JLM	

DESIGN	DRAWN BY	DART AEROSPACE LTD
GP	CB	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. / REV.
LE		D3199 REV. B
DATE		SHEET 1 OF 1
06.11.01		TITLE / SCALE
		BRACKET 1:2

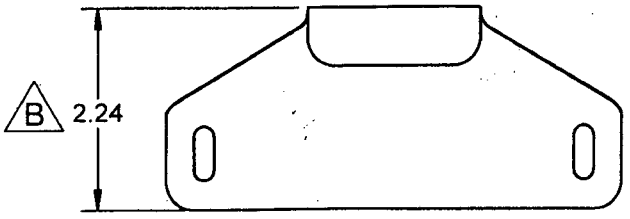
REV	DATE	DESCRIPTION
A	03.08.05	NEW ISSUE
B	06.11.01	2.24 WAS 2.142; ADD FINISH; UPDATE DWG

RELEASED
06.11.20

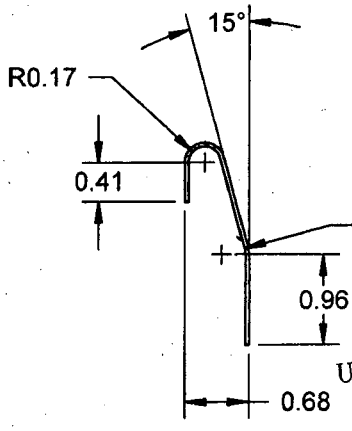




D3199-1 FLAT PATTERN



D3199-1 BRACKET



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36631

NOTES:
1) MATERIAL: AISI 304/316 SS SHEET 0.040" THICK PER MIL-S-5059 (REF DART SPEC. M304S) ANNEALED
2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) AS PER QSI 005 4.3
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED (B)
4) IDENTIFY WITH DART P/N "D3199-1" USING FINE POINT PERMANENT INK MARKER
5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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